

D5419-1 SKYLIGHT WINDOW, LH

D5419-2 SKYLIGHT WINDOW, RH

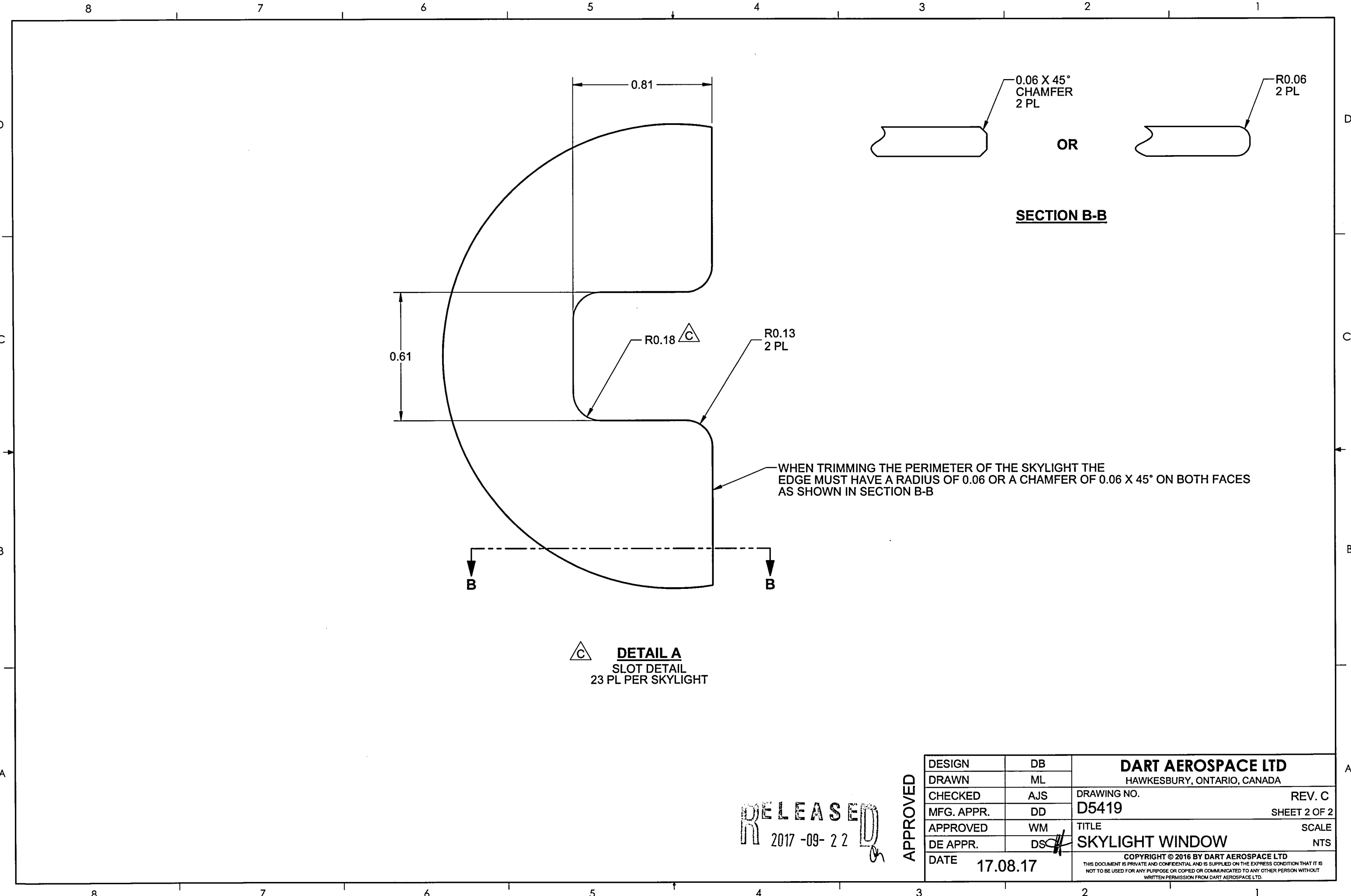
NOTES:

- 1) MATERIAL: MAKROLON FC POLYCARBONATE SHEET, 0.177 THICK, REF DART SPEC MMAKRO177-FC-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: ALL TRIMMED SURFACES MUST BE SANDED SMOOTH WITH 400 GRIT SANDPAPER
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.4 USING 0.125" LETTERS TO A MAX DEPTH OF 0.005" ON WINDOW FLANGE.
- 7) WEIGHT: 6.20 LBS
- 8) THERMOFORM PER DART QSI 022 USING DART MOLD DT10260 FOR D5419-1 AND DART MOLD DT10261 FOR D5419-2
- 9) TRIM OUTER PROFILE OF D5419-1 PER D5419-1-REVC.STEP AND D5419-2 PER D5419-2-REVC.STEP
- 10) MINIMUM THICKNESS AFTER FORMING IS 0.150"
- 11) EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOW
- 12) THE SKYLIGHT MUST BE FREE FROM ANY DEFECTS, OPTICAL DISTORTION IS ONLY PERMITTED WITHIN 4 INCHES OF THE WINDOW PERIMETER. INSPECT PER ASTM F2156
- 13) ENSURE PART IS CORRECTLY POSITIONED ON THE TRIMMING FIXTURE SO THAT THE WINDOW SLOTS AND PERIMETER ARE PROPERLY INDEXED IN RELATION TO THE OVERALL PROFILE.

C	REDUCE SLOT RADIUS FROM R0.31 TO R0.18, ADDED IDENTIFICATION LOCATION, UPDATED NOTES	ML	17.08.17
B	ADD RETENTION SLOTS AROUND PERIMETER OF PARTS, UPDATE NOTES	ML	17.07.14
A	NEW ISSUE	DB	16.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D5419	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SKYLIGHT WINDOW	NTS
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2017-09-22  
EW 17-658

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DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D5419	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SKYLIGHT WINDOW	NTS
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